Work Order ID 69219

Thursday, May 05, 2011 11:45:00 AM



Page 1

Item ID:

D3391-021

Accept



Setup Start



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

Required Date: 5/20/2011

5/5/2011

Start Qty: 1.00

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: <u>//-05-5</u>

Tooling:

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

QC:

Date:

SPC (Y/N):

Reject

Insp.

Work Center ID **Draw Nbr**

Operation Description Set Up/ **Run Hours**

Tool ID

Tool # Plan Code-

Accept Qty

Reject Qty

Number Stamp

D3391

Rev H

100

Skidtubes

Skidtubes

Revision Nbr

Skidtubes

Memo

Cut extrusion to 46.52 +0.010 -0.020

0.00

0.00

110

CNC Bend I

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

11-5-5

120

QC

Quality Control .

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

| W/O: | | | WC | RK ORDER CHANG | GES | | | | g |
|---------|------|-------------------|----------------------|------------------------------|-------------|---------|--------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | | |
| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | A: | Date: _ | |
| | Res | solution: | Disposition | n: | QA: N/C | Closed: | | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORM | ANCE (NC | R) | | _ | |
| DATE | STEP | Description of NC | | | tion B | Verifi | cation | Approval | Approval |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Dat | e Sec | tion C | Chief Eng | QC Inspector |
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| Work | Order | m | 69219 |
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Thursday, May 05, 2011 11:45:00 AM



Page 2

Item ID:

D3391-021

Accept



Setup Start



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

5/5/2011

Start Qty: 1.00

Required Date: 5/20/2011

Req'd Qty: 1.00

Cust Item ID: Customer:

Tool ID

11/05/25

Start

Run

Stop



Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Tool # Plan

Code:

Stop

Reject

Oty

Number Stamp

Reject

Insp.

Sequence ID/ Work Center ID

130

HAAS I

HAAS CNC vertical machine #1

Operation Description

HAAS CNC VERTICAL MACHINING #1

0.00 Memo 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. H

Identify as D3391-1

2-Deburr

Memo

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

A.B

Accept

Qty

150

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

\$ 1/06/01

Drill X1 Aft cap as per Dwg D3391 .1875" dia

| W/O: | - | | WORK ORDER CHANGES | | | | | | | | | | |
|---------|------|-------------------|----------------------|------------------------------|----------|---------|----------|-------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
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| Part No | | PAR #: | | · - | | | | | | | | | |
| | Re | esolution: | | | | | | Date: _ | | | | | |
| NCR: | | 1 | WORK ORD | ER NON-CONFORM | ANCE (NC | R) | | | | | | | |
| DATE | STEP | Description of NC | | ion B Sign | | ication | Approval | Approval | | | | | |
| DAIL | J.L. | Section A | Initial Chief Eng | Action Description Chief Eng | Date | | ction C | Chief Eng | QC Inspector | | | | |
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| Work Ord Thursday, May | | | | | | | | | - | | | Page 3 |
|----------------------------------------------------|-----------------------|-------------------------------------------------|-----------------|------------------------------|--------------------------|-------|--------------|--------------|--------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D3391-021 Fwd Tube As | sembly | | Accept | | | | | Setup | Start Stop | | |
| Start Date: Required Date: Reference: | 5/5/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | | | Cust Item I Customer: | D: | | | | | | # |
| Approvals: | Process Pla | an: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | | |
| Sequence ID/ Work Center I 160 QC Quality Control | D | Operation Description QC2- Inspect parts off ma | achine FAI/FAIB | Set Up/ Run Hours 0.00 | Tool ID | Tool# | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |

170

Quality Control

QC8- Inspect parts - second check

Memo

0.00

on Lulo Was

| | | | | | | | | | ** | |
|---------|-------|---------------------------------------|----------------------|--------------------------|-----------|----------------|--------------|------------|-------------------------------|---------------------------------------|
| W/O: | | | W | ORK ORDER CHA | ANGES | | | 1 | - | \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ |
| DATE | STEP | PROC | EDURE CH | ANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval OC Inspector |
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| Part No | : | PAR #: | Fault Cate | egory: | NC | R: Yes | No DQ | A : | Date: | |
| | R | esolution: | Disposition | on: | QA | : N/C CIO | sed: | | Date: _ | |
| NCR: | | W | ORK ORE | ER NON-CONFO | RMANCI | (NCR |) | | | |
| DATE | STEP | Description of NC | | Corrective Action | Section B | | Verific | ation | Approval | Approval |
| DATE | SIEF | Section A | Initial Chief Eng | Action Descrip Chief Eng | tion | Sign & Date | Secti | on C | Chief Eng | QC Inspector |
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| Work Ord | | | | | | | | | Page 4 |
|-----------------------------------------------------|--------------------------|------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------------------------|--------------------|---|-------------------|--------------------------------|
| Item ID: Revision ID: Item Name: | Ď3391-021 Fwd Tube As | | | Accept | | | | Setup Start | 1 18811(8) 8(8)8 (8) (18) (88) |
| Start Date: Required Date: Reference: | 5/5/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | | | Cust Item II Customer: | D: | | | |
| Approvals: | Process Pla | an: | | | | ite: | - | Run Start Stop | |
| Sequence ID/ Work Center II 180 Skidtubes Skidtubes | D | holes to finis (ONLY DRI 2-Drill Rem- holes drilled 3-Open tow 4-Open Tow 5- open floa 6-Deburr & | bag holes as per Dwg D33 sh size) LL HOLES MARKED "A aining two holes for tow cain previous step cap holes to .208" as per I Ring hole to .640" as per t bag holes 0.328" and course to be batch number Insidrill D3391-021 with D339 | ") Ap using DT 8819 Location Dwg D3391 Dwg D3391 Inter sink as per dwg D33 le aft end. | ng off of .1875" | Tool # Plar Cod | | Qty | Reject Insp. Number Stamp |
| 190 | | QC5- Inspect part compl | eteness to step on W/O | 0.00 | "* · | | | | |

Quality Control

Memo

0.00 Sulvolcz

| W/O: | | | WORK ORDER CHANGES | | | | | | | | | | |
|---------|------------|-----------------------------------------------|----------------------|------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|--------|-------------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PRO | CEDURE CH | ANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
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| Part No | • | PAR #: | Fault Cat | egory: | NCR: Yes | No DQ | A: | Date: | | | | | |
| | R | Resolution: Disposition: WORK ORDER NON-CONFO | | | _ QA: N/C Cle | osed: | | Date: | | | | | |
| NCR: | 1 ' | V | VORK ORE | DER NON-CONFORMA | NCE (NCR |) | | | | | | | |
| DATE | STEP | Description of NC | I 1A1 I | Corrective Action Section | on B Sign & | | cation | Approval | Approval | | | | |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | . Date | Sect | ion C | Chief Eng | QC Inspector | | | | |
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Work Order ID 69219

Thursday, May 05, 2011 11:45:00 AM



Page 5

Item 1D:

D3391-021

Accept



Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

5/5/2011

Start Qty: 1.00

Required Date: 5/20/2011

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date: Date: ___ Run Start

Stop

Sequence ID/ **Work Center ID**

200

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QS1005 4.1

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

11-6-3

210

Quality Control

QC3- Inspect Part Finish

0.00

0.00

1 0 BE11/06/03

220

Skidtubes Skidtubes

Skidtubes

Memo

1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: M11667

exp. date: 20 /1/8/30 cure time 12hrs. as per QSI015 2- grind crossbolt flush

3-back drill crossbolt if necessary

0.00

0.00



| | • | | | | | | | | |
|---------|------|-------------------|----------------------|------------------------------|----------------|--------------|--------|-------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANGE | ES | | | | , |
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cat | egory: | NCR: Yes | No DQ | A: | Date: _ | |
| | Re | esolution: | | | | | | Date: _ | |
| NCR: | | • | WORK ORI | DER NON-CONFORMA | NCE (NCF | R) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verific | cation | Approval | Approval |
| DAIL | JILI | Section A | Initial Chief Eng | Action Description Chief Eng | Sign 8 Date | Secti | ion C | Chief Eng | QC Inspector |
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Thursday, May 05, 2011 11:45:00 AM



Page 6

Item ID:

D3391-021

Accept



Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

5/5/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Required Date: 5/20/2011

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

230

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

235

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

240



Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

START TIME: 8

OVEN TEMPERATURE: FINISH TIME:

| W/O: | | | W | ORK ORDER CHANG | ES | | | | |
|---------|--------|-------------------|----------------------|------------------------------|----------------|--------------|--------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No |): | PAR #: | Fault Cate | egory: | NCR: Yes | No DQ | A: | Date: | <u>.</u> |
| | | esolution: | | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | ANCE (NCF | R) | | | _ |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verifi | cation | Approval | Approval |
| DAIL | JILI | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Sect | ion C | Chief Eng | QC Inspector |
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| Work Orde Thursday, May 0 | | | The second secon | | | | | | | | Page | 7 |
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| Revision ID: | D3391-021 | | | Accept | | | | | Setup | Start Stop | | |
| | Fwd Tube Ass 5/5/2011 5/20/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | | | Cust Item Customer: | D: | | | | | | |
| Approvals: | Process Pla | n: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | | |
| Sequence ID/ Work Center ID 250 |) | Operation Description QC3- Inspect Part Finish | • | Set Up/ Run Hours | Tool ID | Tool# | Plan Code | Accept Qty | t Rej Qty | y] | Reject Insp. Number Stamp | |
| QC Quality Control | | Memo | | 0.00 | 1 . | | | | | <u> </u> | | J 1 |
| 255 | | Skidtubes | | 0.00 | | | | 1 | | d | الما الما | ١٥ |

Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per

DWG ****

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

| W/O: | | | W | ORK ORDER CHANG | ES | | | t |
|---------|------|-------------------|----------------------|------------------------------|----------------|-------------------|---------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | Date Qt | y Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cat | egory: | _ NCR: Yes | No DQA : _ | Date: _ | |
| | Re | esolution: | Dispositi | on: | _ QA: N/C Cld | osed: | Date: _ | |
| NCR: | | | WORK OR | DER NON-CONFORMA | NCE (NCR |) | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verification | n Approval | Approval |
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| Work Ord Thursday, May | | | | | | | | | | | | Page |
|----------------------------------------------------------------|----------------------------------------|-------------------------------------------------|-------------------|-----------------------------------|--------------------------|---------------|--------------|---------------|--------------|--------------|------------------|----------------|
| Item ID: Revision ID: | D3391-021 | | | Accept | | | | | Setup | Star Stop | : : | |
| Item Name: Start Date: Required Date Reference: | Fwd Tube As 5/5/2011 : 5/20/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | | | Cust Item I Customer: | D: | | | | | | |
| Approvals: | Process Pl | an: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Star Stop | | |
| Sequence ID/ Work Center I 260 Packaging Packaging | D | Operation Description Identify as per dwg & Sto | ock Location: 100 | Set Up/ Run Hours 0.00 D4(2 | Tool ID - 742-043/ | Tool# B692 | Plan Code | Accept Qty | t Rej Qty | | Reject Number | Insp. Stamp |

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

280

Quality Control

Page 8

| W/O: | · | | W | ORK ORDER CHANG | GES | | | | | 4. |
|---------|------|-------------------|------------|----------------------------------------------|------------|-------|----------------|--------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | CEDURE CHA | NGE | В | у | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR: ` | Yes N | | A: | Date: | |
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| NCR: | 7 | | WORK ORD | ER NON-CONFORM | ANCE (1 | ICR) |) | | | |
| DATE | STEP | Description of NC | 1 | | ction B | ian P | | cation | Approvai | Approval |
| | 0.2. | Section A | Chief Eng | nitial Action Description nief Eng Chief Eng | | | Sign & Section | | Chief Eng | QC Inspector |
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Picklist Print

Thursday, May 05, 2011 11:45:07 AM

Work Order ID: 69219

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 5/5/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A□05.09.13□New issue□

KJ/JLM□ 1PP B□06.02.10□Dwg rev.D ecn 773 □EC□

1PP C□06.05.02□Added inspections $\square EC \square$

IPP D 07.03.13 rev F dwg

ECIPP E 07.11.07 revG dwg ecn1053P EC verified by: DD

IPP Rev:f ECN 1056 07-11-12 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev J 09.02.02 added hardware EC verifified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|-----------------------|------------------|-----------------|--------------------------------|-------------------------|-------------|--------------|-----------------|----------------|--------|
| D6013-047 | | Manufactured | No | | | 100 | Each | 27.0000 | 1 | 1 | | | |
| D3670-4-200 | | Manufactured | No | Location LG | 26547 | <u>Loc</u> () | Qty 27 27 Each | Loc Code 58.0000 | | 4 |) _{//} | -5- | -5 |
| SPACER | | | | Location LG | B689 | SO Loc | <u>Otv</u> 58 58 | Loc Code | (2) | | P. | 11-0 | 6-3 |
| D3401-041 Tow Cap Assembly | | Manufactured | No | | | 255 | Each | 16.0000 | 1 | jų_ | - 11/06/ | 07 | |

Location Loc Qty Loc Code FP007 16 46029 61505 12

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| W/O: | | | W | ORK ORDER CHANG | ES | | | | | ; |
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | , | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Ca | tegory: | _ NCR: Y | es N | o DQA: | | Date: | |
| | R | esolution: | Disposit | ion: | _ QA: N/ | Clos | sed: | | Date: _ | |
| NCR: | | • | WORK OR | DER NON-CONFORM | ANCE (N | CR) | | _ | | |
| DATE | CTED | Description of NC | | Corrective Action Section B | | | Verifica | tion | Approval | Approval |
| DAIE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | gn & ate | Section C | | Chief Eng | QC Inspector |
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Page 2

Thursday, May 05, 2011 11:45:07 AM

Work Order ID: 69219

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly

NAS1149C0332



Start Date: 5/5/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Oty: 1.00

D3564-13

Wearshoe

No Manufactured

Manufactured

Purchased

Purchased

No

No

No

255

Each

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| DATE | STEP | Description of NC | | | tion B | | cation | Approval | Approval |
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Picklist Print

Thursday, May 05, 2011 11:45:07 AM

Work Order ID: 69219

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 5/5/2011

Required Date: 5/20/2011

Page 3

Start Qty: 1.00

Required Qty: 1.00

D3672-1

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| Part No: PAR #: Fault Category: NCR: Yes No DQA: | i: | Date: | |
| Resolution: Disposition: QA: N/C Closed: | | _ Date: _ | |
| NCR: WORK ORDER NON-CONFORMANCE (NCR) | | | |
| DATE STEP Description of NC Corrective Action Section B Verifica | Verification A | | Approval |
| DATE STEP Section A Initial Action Description Sign & Section Chief Eng Chie | | Chief Eng | QC Inspector |
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| DART AEROSPACE LTD | Work Order: | 49219 |
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| Description: Float Skidtube (412) | Part Number: | D3391-1 |
| Inspection Dwg: D3391 Rev: H | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| X First Article | Prototype |
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| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments | |
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| Measured by: | B.A | A | Audited by: | onl | Prototype Approval: | N/A |
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| Date: | 1105 | 25 | Date: | 11/08/11 | Date: | N/A |
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| Rev | Date | Change | Revised by | Approved |
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| Α | 06.04.27 | New Issue P/O D3391-011/-021 | KJ/JLM | |
| В | 06.06.19 | Tolerances revised per D3391 Rev. E | KJ/JLM | · |
| С | 07.03.21 | Dimensions removed per Dwg rev. F | KJ/JLM | |
| D | 07.11.23 | Dwg Rev. updated | KJ/EC/DD | |
| E | 09.12.14 | Dwg Rev updated | KJ \$ | |

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| | R | esolution: | Disposit | ion: | | QA: N/C | Close | d: | | Date: _ | |
| NCR: | | W | ORK OR | DER NON-C | ONFORMA | NCE (NO | CR) | | | | |
| DATE | STEP | Description of NC | | Corrective A | | | - 0 | Verific | | Approval | Approval |
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NOTE: Date & initial all entries

SHOP COPY **RETURN TO ENGINEERING** LINICANTROLUED CODY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER SEAL WITH SIKAFLEX-241/-291 PRIOR TO INSTALLATION OF D3391-015 AFT TUBE ASSEMBLY D3553-3 GASKET REF D3537-7 WEARPAD REF С D3553-1 GASKET REF D3537-1 WEARPAD AN960C10L WASHER DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0 499 DIM AND D3591-1 BUSHING AJS 08.08.20 SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM В, WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)

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COPYRIGHT 9 2005 BY DART AEROSPACE USA, INC
THIS DOCUMENT SPRINT AND CONFIDENTIAL AND IS SUPPLETON THE EUROPES COMPITION THAT IT IS
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412 FLOAT SKIDTUBE

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AND INSTALL D3591-1 BUSHING D3566-13 GASKET REF -D3566-5 GASKET D3566-1 GASKET D3564-13 WEARSHOE D3566-1 GASKET REF D3564-3 AN3C4A BOLT (1) WEARSHOE AN960C10L WASHER (1) D3564-1 4 PL WEARSHOE AN3C6A BOLT AN3C6A BOLT AN3C6A BOLT (1) AN3C4A BOLT (1) D3564-5 LAN960C10L WASHER (1) AN960C10L WASHER AN960C10L WASHER (1) WEARSHOE 4 PL 6 PL 2 PL 20 PL AN3C7A BOLT -AN960C10L WASHER 8 PL D3391-041 ASSEMBLY В REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY ADD SS WEARSHOE, GASKET D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST REMOVE FWD SADDLE HOLE -011/-021 DESCRIPTION **GENERAL NOTES** CHANGE TOLERANCE, EASE MANUFACTURE Ε -041 Y UPDATE TOLERANCE, CHANGE HOLE SIZE D CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 FWD TUBE ASSEMBLY С LENGTHEN AFT EXTENSION POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 D3391-01 MID TUBE ASSEMBLY AFT TUBE ASSEMBLY В DRAWING UPDATES SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS, COAT ALL EXPOSED FASTENERS WITH **NEW ISSUE** D3564-DESCRIPTION LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS REV. D3564-WEARSH OFF POWDER COATING WITH MEK DEGREASER. DESIGN DART AEROSPACE USA, INC PH TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DRAWN UNITS: INCHES UNLESS OTHERWISE NOTED CHECKED DRAWING NO. USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES AN3C4A

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MS27039C4-12 SCREW

AN960C416L WASHER

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D3672-3 WASHER

SEAL WITH SIKAFLEX-241/-291 PRIOR TO INSTALLATION OF

D3391-011

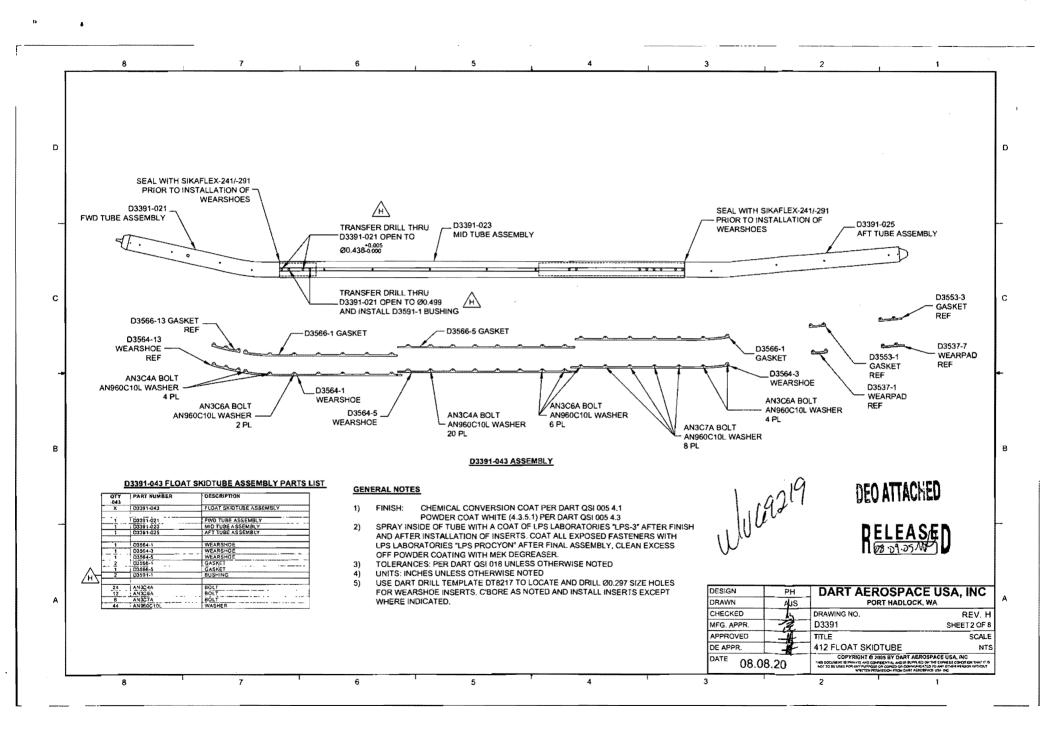
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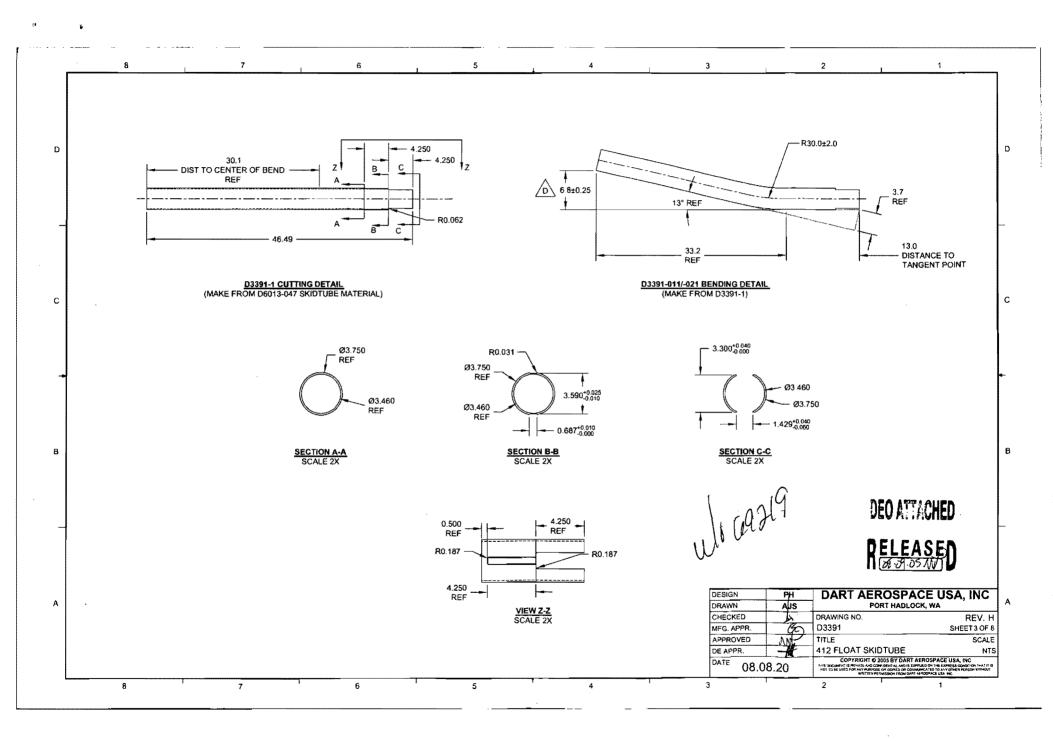
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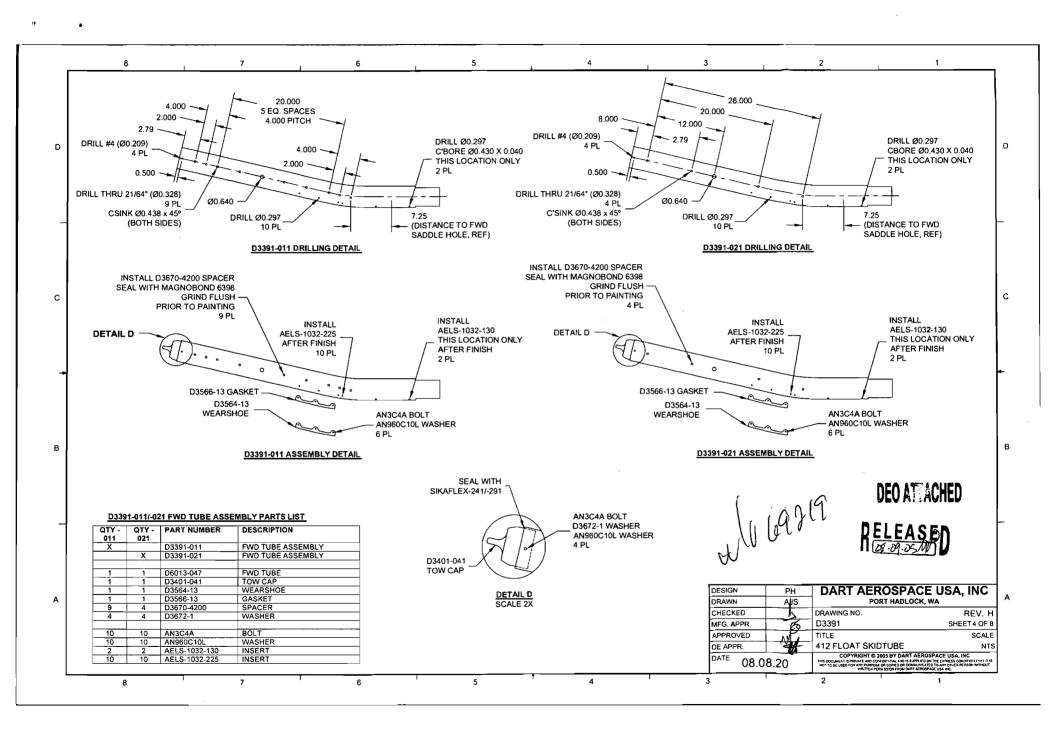
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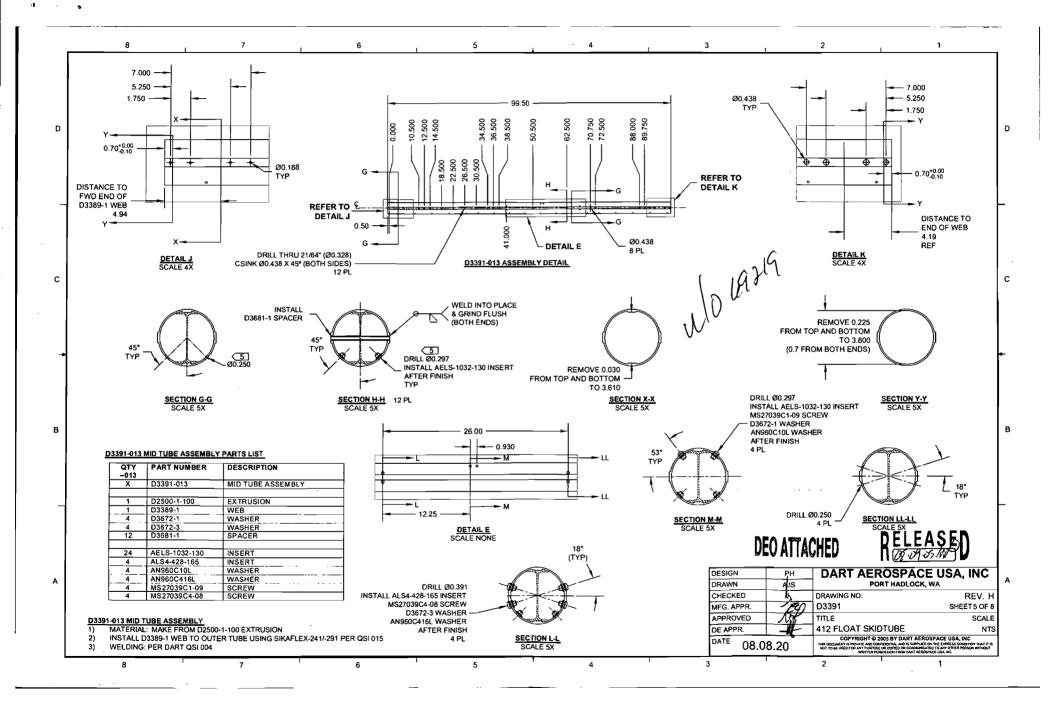
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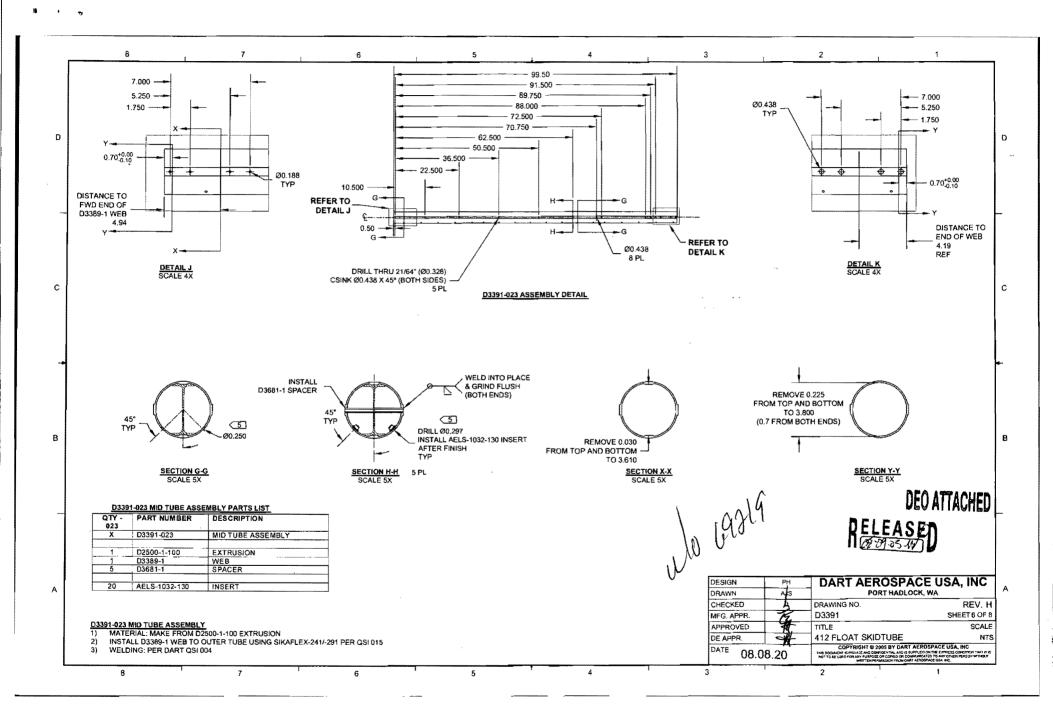
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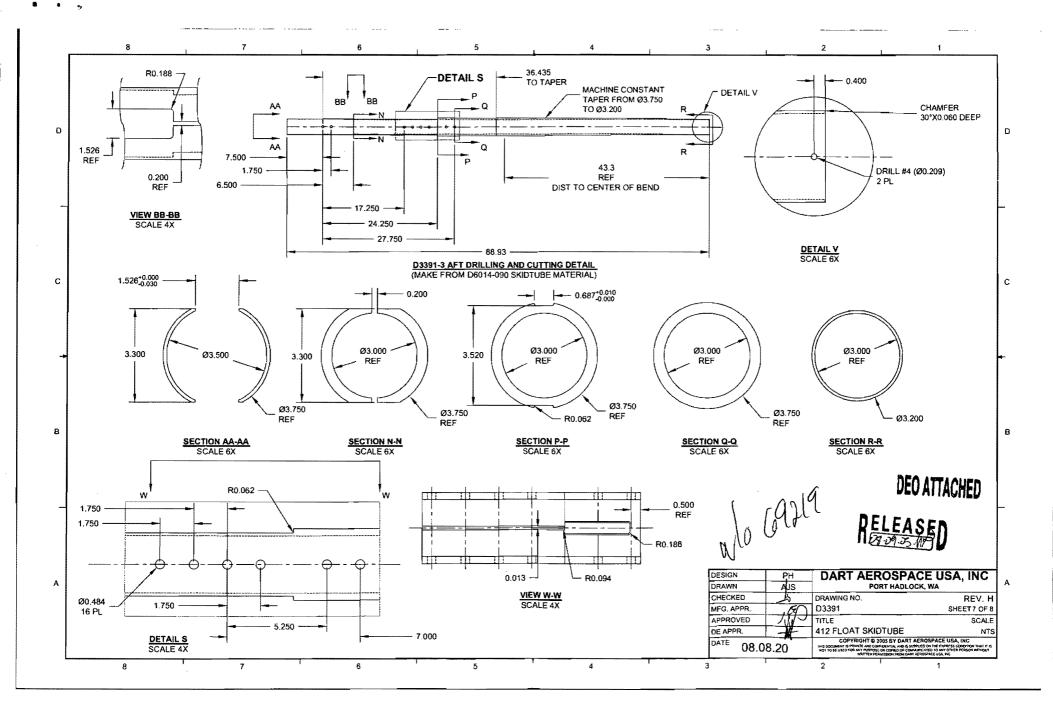
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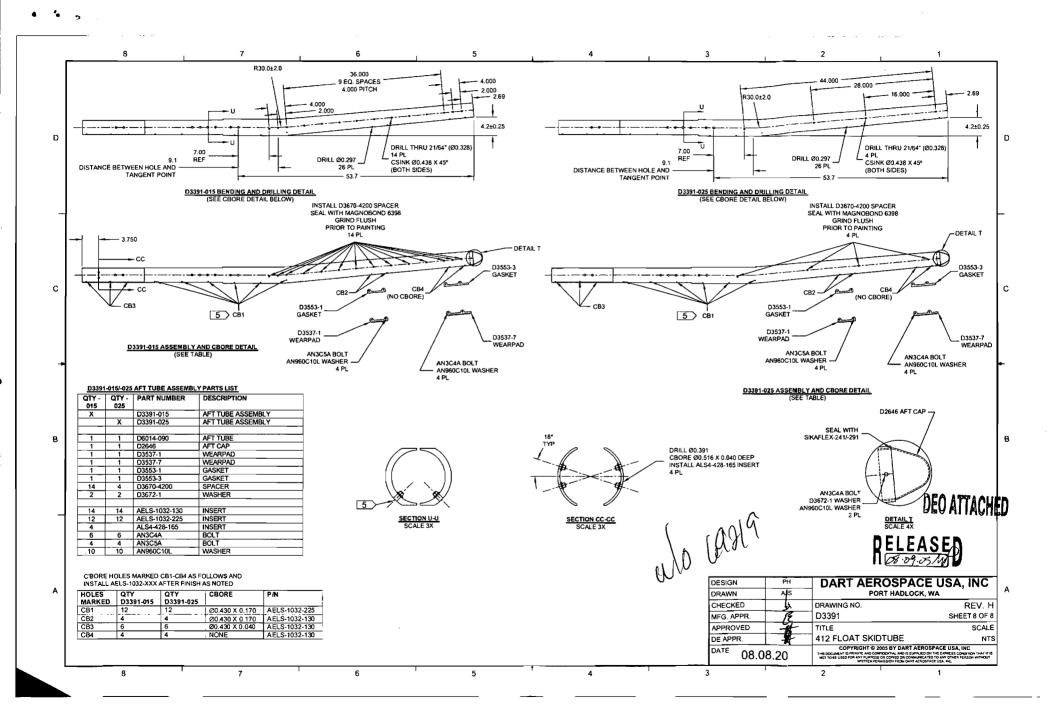
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| Part No | | PAR #: | gory: | NCR: Yes | No DQ A | ۸: | _ Date: _ | | |
| | Re | esolution: | Dispositio | n: | QA: N/C CI | osed: | | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NCR | 3) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verific | ation | Approval | Approval |
| DATE | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section | on C | Chief Eng | QC Inspector |
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| DRAWING NO. | TITLE | | REV. H DA | ART AEROSPACE USA, II | NC D.E.O. NO. | SHEET NO. | SCALE |
|-------------|-----------|-----------|-----------|--------------------------|---------------|---------------|-------|
| D3391 | 412 FLOAT | SKIDTUBE | , | ENGINEERING ORDER | D3391-H-1 | SHEET 1 OF,1 | NTS |
| DRAWN | P | CHECKED | <u>.</u> | MFG. APPR. | APPROVED MAD | DE APPR. | _ |
| DATE 09 | .09.23 | DATE 04.0 | 4.24 | DATE 09/09/25 | DATE 09/09/30 | DATE 09/09/30 | |

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT-OF-LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

DELEASED 2010 -02- 02

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w/6 bayla

| Dart Aeı | rospace | e Ltd | | • | | ₹ Z | | | رد المسترد والم | , | | |
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| W/O: | | | | | WORK | ORDER CHA | NGES | | | 4 | | φ. •° (0 |
| DATE | STEP | 44 | | PROC | EDURE CHANGE | i i i | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | f. | · | | | | | | | | | · | |
| | ,,, | | | | Section 1 | | | | | | - | |
| | ٠ | | | | | · · · · · · · · · · · · · · · · · · · | - | | | | * [: | |
| Part No | : | | PAR # | | Fault Category: | | NC | R: Yes | No DQ | \: | Date: _ | |
| | R | esolution: | , , , , , , , , , , , , , , , , , , , | | Disposition: | | QA | : N/C C | losed: | | Date: _ | |
| NCR: | | | | W | ORK ORDER N | · | RMANCE | | <u>.</u> | N. 78. 3 | | |
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| NCR: | | W | ORK OR | DER NON-CONFORMANCE | d. | | | |
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| | | Description of NC | | Corrective Action Section B | | Verification | Annroyal | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng - | Sign & Date | Section C | Approval Chief Eng | QC Inspector |
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